Work Order ID 56649 March 3, 2010 1:12:28 PM Page 1 Item ID: D3546-1 Accept Revision ID: Setup Start Item Name: Clip Stop Start Date: 03/03/2010 Start Qty: 6.00 Required Date: 08/03/2010 Cust Item ID: Req'd Qty: 6.00 Customer: Reference: Approvals: Process Plan: Run Tooling: Start Date: QC: Date: SPC (Y/N): Stop Date: Sequence ID/ Operation Set Up/ Work Center ID Draw Description Draw Plan Accept Reject Reject Insp. Run Hours Number Draw Nbr Rev. Code Qty Revision Nbr Qty Number Stamp D3546 Rev A 100 MAT NOT PULLED 0.00 FLOW WATER JET Waterjet Memo 0.00 FLOW CNC Waterjet 1-Cut as per Dwg D3546 □Dwg Rev: Prog Rev: A 2-304,000 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1810-3-9 Memo 0.00 Quality Control 120 QC8- Inspect parts - second check Memo Quality Control

Dart	Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PROC	CEDURE CHA	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							7:	
Part No		PAR #:						
	R	esolution:	_ Disposition	on:	_ QA: N/C C	osed:	Date: _	
NCR:		W	ORK ORD	ER NON-CONFORM	ANCE (NCF	₹)		
DATE	STEP	Description of NC			tion B	Verification	n Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8	Section C	Chief Eng	QC Inspector
								19.
								1 1

Work Order ID 56649 March 3, 2010 1:12:28 PM Item ID: D3546-1 Accept Revision ID: Setup Start Item Name: Clip Stop Start Date: 03/03/2010 Start Qty: 6.00 Required Date: 08/03/2010 Cust Item ID: Req'd Qty: 6.00 Customer: Reference: Approvals: Process Plan: Date: Run Tooling: Start Date: QC: Date: SPC (Y/N): Stop Date: Sequence ID/ Operation Work Center ID Set Up/ Draw Description Draw Plan Accept Reject Reject Run Hours 130 Number Rev. Qty Code Qty Number 0.00 NC BRAKE Brake NC Memo Brake NC So 10/03/11 Form as per Dwg D3546 140 QC5- Inspect part completeness to step on W/O 0.00 Memo 0.00 Quality Control 150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

OVEN TEMPERATURE:

Powdercoat

Powder Coating

Memo

START TIME

FINISH TIME:

Page 2

Insp.

Stamp

ATE STEP	HANGE By Date Qty Approval Chief Eng / Prod Mgr Approval QC Inspector
39 150	uge 160 \$ 0.03.24 (0.03)
	mge 100 10 Corred 2

Part No: <u>D 35 46-</u>	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
Resolution:		Disposition:	QA: N/C Closed:	_ Date:	

WORK ORDER NON CONFORMANCE (NOD)

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
		Description of NC Corrective Action Section		Description of NC Corrective Action Section B			Approval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector
								L

Work Order ID 56649

March 3, 2010 1:12:28 PM



Page 3

Item ID:

D3546-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Clip

Start Date: 03/03/2010 Required Date: 08/03/2010

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

Description

Operation

QC3- Inspect Part Finish

Memo

0.00

Set Up/ Run Hours

0.00

Draw Number

Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp.

Number Stamp

Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location: 57245

0.00

0.00

10-3-18

180

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

Memo

0.00

CZ10/3/19

Dart Aerospace Ltd

13-100012-37-58										
W/O:			W	ORK ORDER CHANG	GES					-
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n:	QA:	N/C CI	osed:		Date:	
NCR:		V	WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	0755	Description of NC		Corrective Action Sec	ction B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect		Chief Eng	QC Inspector
NOTE: D	ate & initi	al all entries								

Status

Picklist Print

March 3, 2010 1:12:33 PM

Work Order ID: 56649

Parent Item: D3546-1

Parent Item Name: Clip

Comments:

IPP Rev:A New Issue 06-09-27 JLM

Start Date: 03/03/2010

225.4922 1.3263

Required Date: 08/03/2010

Qty

Issued

13-9

Required Qty: 6.00

Date

Issued

		00 07 27	JESTVI						0	
Component Item ID/	Replacement	Mfg/	Bin	n e					Start Qty: 6.00	
Item Name	Item ID	Purch		Primary Location	Last Location	Route Seg ID	Unit of	Qty on	Remaining	
M304S18GA		au rev 19				Seq ID	Measure	Hand	Qty To Pick	j
I DESCRIPTION AND RESTRICTION OF THE		Purchased	No			100	72			

304/316 .050 Sheet

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
MAT	225.4921632	
108156	0.98526316	
111743 112885	23.7174	
113062	72.7895 128 (1217 g	

100

sf

Dart	Aeros	pace	Ltd

W/O:			W	ORK ORDER CHANG	ES				I Tobasa
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Die.		
								11	
									14 - B
								4.	1 4
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	s No DC	A:	Date:	1
		esolution:							
NCR:		\	WORK ORE	DER NON-CONFORMA	ANCE (NO	R)			
DATE	CTED	Description of NC		Corrective Action Section		Verif	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	Sec Sec	tion C	Chief Eng	QC Inspector
i i									A
									14
								da d	
					*				

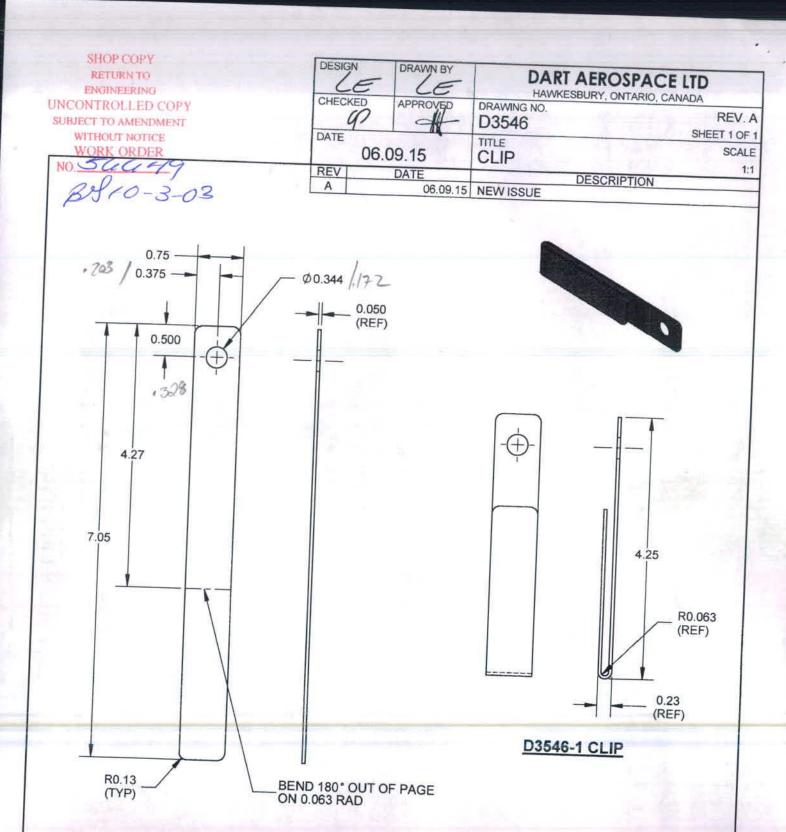
DART AEROSPACE LTD	Work Order:	5664
Description: Clip		
	Part Number:	D3546-1
Inspection Dwg: D3546 Rev: A	7022	
Novich	97	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual	Accept	Reject	Method of	0
7.05	+/-0.030	Dimension			Inspection	Comments
0.500	+/-0.010	7.046	8			
0.75	+/-0.030	2501	×			
0.375	+/-0.010	754	*			
0.050	+/-0.010	375	8			
Ø0.344	+0.006/-0.001	1049	*		1 5	
	10.006/-0.001	1347	8			
			16	11 -		
ured by:	3	Audited by:	8,	Pi	ototype Approva	I: N/A
Date:	0-3-9	Date:	10/03/10		Date	29.37.6.5

Dart Aerospace L	td
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Categ	gory:	NCR: Yes	No DQA:	Date: _				
Resolution:			Disposition	1:	QA: N/C CI	QA: N/C Closed: Da					
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)					
DATE	STEP	STEP Description of NC Section A		ion B	Verification	tion Approval	Approval				
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
		(14) (1									



D3546-1F FLAT PATTERN

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA) 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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Dart Aeros	pace Ltd
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W/O:	£.	ij.	V	ORK ORDER CHANG	ES							
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:				Fault Category: NCR			CR: Yes No DQA: Date:					
Resolution:			Disposit	_ Disposition: QA			ed:	Date:				
NCR:		\	WORK OR	DER NON-CONFORMA	ANCE (N	CR)						
DATE	STEP	Description of NC	Corrective Action Section B			Verification		ation	Approval	Approval		
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		n & ate		Section C Chief Eng		QC Inspector		